

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008156**Date Inspected:** 31-Jul-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Liu Xiaozhong, Xu Le Feng, Zhang Zhineng			CWI Present:	Yes	No
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No N/A
				Delayed / Cancelled:	Yes	No N/A

Bridge No: 34-0006**Component:** Tower Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Amit K. Juvekar, was present during the times noted above for observations relative to the work being performed.

This QA Inspector observed the following work in progress:

Bay11, Lift 4, Skin C, West Tower.

FCAW welding of weld joint WSD1-FCSA4-2C/C-19, 20, 5, 6 & WSD1-FCSA4-2B/C-5, 6; located on Bay11, Lift 4, Skin C, West Tower. Welder is identified as 69712, 67501, 070008, 069469, 070022, 67550; ZPMC Quality Control Inspector (QC) is identified as Liu Xiaozhong. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2332-TC-P5-F.

Bay11, Lift 4, Skin C, West Tower.

FCAW welding of weld joint WSD1-FCSA4-2B/C-1B & WSD1-FCSA4-2C/C-15B; located on Bay11, Lift 4, Skin C, West Tower. Welder is identified as 040759, 047701; ZPMC Quality Control Inspector (QC) is identified as Zhang Zhineng. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2232-TC-U5-F.

Bay11, West Tower, Angle Plate.

SAW welding of weld joint SD1-A5002-1-1A & SD1-A5002-2-1A & SD1-A5002-3-1A & SD1-A5002-4-1A; located on Bay11, West Tower. Welder is identified as 042195 Yang Meizhen; ZPMC Quality Control Inspector (QC) is identified as Xu Le Feng. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-3221-U5B-S-1.

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This QA Inspector carried out NDE on following:

Bay 11, West Tower, Lift 1.

This QA inspector performs Random Visual Testing (VT) of area previously tested and accepted by ZPMC Quality Control personnel. The members are identified as

- 1) WSD1-A423E/H-50 TO 65. 9M Diaphragm to Skin A Fit Lugs.
- 2) WSD1-A423E/H-170 TO 185. 13M Diaphragm to Skin A Fit Lugs.
- 3) WSD1-A423F/H-27 TO 34. 15M Diaphragm to Skin A Fit Lugs.
- 4) WSD1-A423F/H-79, 73. 15M Diaphragm to Skin A Welds.
- 5) WSD1-A423E/H-186. 13M Diaphragm to Skin A Welds.
- 6) WSD1-A423E/H-117. 9M Diaphragm to Skin A Welds.

Bay 11, West Tower, Plange of Strut Plates.

This QA inspector performs Magnetic Particle Testing (MT) of approximately 15% area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report (TL-6028) for this date. The members are identified as

- 1) WD1-A6001-1-3A/B.
- 2) WD1-A6001-2-1A/B.
- 3) WD1-A6001-1-4A/B.
- 4) WD1-A6001-2-2A/B.
- 5) WD1-A6001-3-4A/B.
- 6) WD1-A6001-4-4A/B.
- 7) WD1-A6001-4-2A/B.
- 8) WD1-A6001-5-4A/B.
- 9) WD1-A6001-5-2A/B.
- 10)WD1-A6001-3-3A/B.
- 11)WD1-A6001-4-1A/B.
- 12)WD1-A6001-4-3A/B.
- 13)WD1-A6001-5-1A/B.
- 14)WD1-A6001-5-3A/B.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod, 13482570045, who represents the Office of Structural Materials for your project.

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Inspected By:	Juvekar,Amit	Quality Assurance Inspector
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Reviewed By:	Clifford,William	QA Reviewer
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